Work Orde		704		*115	5704*						Page 1		
Revision ID: Item Name: Start Date:		Start Qty: 100.00			*N900		100	<b>)</b> * <sup>9</sup>	Setup Sta	17	S1* S2*	<u> </u>	
Required Date: Reference:	4/04/14	Req'd Qty: 100.00	*100	)*	Customer:								
Approvals:	Process Plan QC:	: MLJ	Date: N-04-C	Tooling: SPC (Y/N):		ate:		I	Run Sta Sto	^I <i>V</i> I	R1*	r	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	J	
Draw Nbr	Revis	sion Nbr							· · · · · · · · · · · · · · · · · · ·			· .	
D3595	Rev A	A											
*1 \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		FLOW WATER JET  Memo  1-Cut as per Dwg Rev:	Dwg D3595	0.00				100			DAS 23 9-89		
ne o 125		Prog Rev:	A										
*110		QC2- Inspect parts off m	achine FAI/FAIB	0.00				100	0		DAS 23	14-09-9	
QC Quality Control		Memo		0.00				100			- <b>9-89</b>		
120		QC8- Inspect parts - seco	ond check	0.00							DAS <b>38</b>		
*120*		Memo		0.00				100			9-89	14-9-12	

Memo

Quality Control

DQA:			Date:											•	
						WORK ORDER NON-	-C(	ONFO	RMANCE / U				_	_	AEROSPACE
QA Closed:	-		Date:		-						W	ork Order up	date only	$\perp$	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
	•				<del></del>	Rework			Skid-tube	Crosstube		1	Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	٦	Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo.			<del></del>		Suspected Unapproved			Large Fab	Composite		]	Supplier	_l	
Root					Desci	ription of work order update	l	nitial	Act	tion		Sign &		Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification		QC Inspector
Design	_														
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Equip/Tooling															
Handling/Pre															
Material															
Operator						:									
Offset/Setup	_														
Process															
Supplier															
Training	_														
Transport	_			1											
Unapproved					<u> </u>									$\perp$	
							FAI	ULT CAT	<b>TEGORY</b>						
Landii	_	1			_	General		1 .		1		7	_	_	
		Bending			<u> </u>	Bend		1	Program		_	Outside Dim		-	Pressure/Forced
	_	Centre No	t Concer	ntric	-	BOM/Route	_	Grain				Over/Under	<del>-</del>	_	Set-up
		Cracks				Broken/Damage/Defect		Hardwa			_	Part Incorred	<b>-</b>	$\neg$	Temperature/Cure
	-	Crimp/Kin	ık/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	1	ion Incomplete/U	•		Part Lost/Mi	ssing		Weld
		Cuffs			ļ	Contamination		4	ions Incomplete/	Unclear	<u> </u>	Part Moved	Ĺ	ٰ ٰٰٰٰٰ	Wrong Stock Pulled
		Crushing				Countersink		1 7	ned/off center		<u> </u>	Positioned V	· ·		
		Heat Trea			_	Cut Too Short		Mislabe				Power Loss/	Surge		Other
		Inspection	•	Tube	<u> </u>	Drawing		Misread					<del></del>		
		Marks/Ch			<u> </u>	Drill Holes	<u>_</u>	Off-set							· · · · · · · · · · · · · · · · · · ·
	$\overline{}$	Turning Se			<u> </u>	Finish		₹	Calibration				<del></del>		
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of S	Sequence						

<b>Work Orde</b> April-04-14 10:		5704			*115	5704*						•	Page 2
Revision ID:	D3595-063-5		*N900040100* Setup										S1* S2*
Start Date: Required Date: Reference:	4/04/14 4/04/14	<b>Start Qty:</b> 100.00 <b>Req'd Qty:</b> 100.00		*100* *100*		Cust Item Customer							
Approvals:	~~	n:	Date:_ Date:_		Tooling: _ SPC (Y/N):		Date: Date:			Run	Start Stop		R1* R <i>2</i> *
Sequence ID/ Work Center II	)	Operation Description Identify as per dwg & Stoo	k Location	LG051	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*120* Packaging Packaging		Memo		-	0.00				_/00		<	Spl	4-19-1

0.00

0.00

140

\*140\*

Quality Control

QC21- Final Inspection - Work Order Release

Memo

14/9/11 H

DQA:		Date	:		WORK ORDER NON	c	ONICOI		LIDDATE				DART
QA Closed:		Date	:		WORK ORDER NON	-((	JNFU	RIVIAINCE /	UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	or.				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
WOIR Old	-1.				Rework	וו		Skid-tube	Crosstube		7	Water Jet	Engineering
Part N	No.				Scrap			Machining Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing		₹	re/Packaging	Other
NCR N	No				Suspected Unapproved			Large Fab	Composite	_		Supplier	
Root	<del></del>			Desc	ription of work order update		I Initial	A	 Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	ı	nief Eng		scription		Date	Verification	QC Inspector
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Doc/Data													
Equip/Tooling		Ì											
Handling/Pre			ł										
Material													
Operator `													
Offset/Setup													
Process													
Supplier													
Training		İ											
Transport								1					
Unapproved	<u> </u>		<u> </u>	<u> </u>		<u> </u>							
					<del></del>	FA	ULT CA	regory					<u> </u>
Landir	ng Gear		1	_	General	_	1			_	7	_	_
	Bendin			<u> </u>	Bend	_	1	rogram		_	Outside Dim	<del>}</del>	Pressure/Forced
	_	Not Conce	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			_	Over/Under		Set-up
	Cracks				Broken/Damage/Defect	_	Hardwa				Part Incorred	<u> </u>	Temperature/Cure
		Kink/Ripple	e/Wave	- }-	Burrs	_	4 '	ion Incomplete/	•		Part Lost/Mi	_	Weld
	Cuffs			-	Contamination	<u> </u>	4	tions Incomplete	-		Part Moved		Wrong Stock Pulled
	Crushin				Countersink		1 7	ned/off cente	r .	_	Positioned V		<b>¬</b>
	Heat Tr			<u> </u>	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	Other
	<b>─</b> ─ '	ion Strip ir	1 Tube	$\vdash$	Drawing	<u></u>	Misread						
	Marks/				Drill Holes	<u> </u>	Off-set						
		Sequence		<u> </u>	Finish	_	4	Calibration			<u> </u>		
	Wave/1	wist in Tu	be :		Fit/Function	1	IOut of 9	Sequence					

## **Picklist Print**

April-04-14 10:17:06 AM

Work Order ID: 115704

**Parent Item Name:** 

\*115704\*

Parent Item:

D3595-063-530

Rubber Cushion

\*D3595-063-530\*

**Start Date:** 4/04/14

Required Date: 4/04/14

**Start Qty: 100.00** 

Required Qty: 100.00

**Comments:** 

IPP Rev:A New Issue 07-08-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO80S.125		Purchased	No		· · · · · · · · · · · · · · · · · · ·	100	sf	736.5344	0.0206	(3)		DAS	
*MNFO80	S 125*								**			23	14-09-9

**NEOPRENE SHEET 0.125** 

<b>Location</b>	Loc Qty	Loc Code	
MAT052	736.5344		
115916	131.1044		
94539	605.43		94539

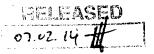
DQA:		Date	:	·	WORK ORDER NON		21150	Dagaa.or / 11					DART
QA Closed:		Date	:		WORK ORDER NON	-C(	ONFO	RMANCE / U		Wor	k Order up	date only	AEROSPACE
	***************************************				DISPOSITION				AGAINST I			•	
Work Orde	er:				DISPOSITION			<u></u>	AGAINST	——	AKTIVICIAT)		
					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo				Scrap	1		Machining	Small Fab			d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming	Finishing	_	Rec/Stor	e/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier	
Root				Desci	ription of work order update		nitial	Ac	tion		Sign &		
Cause	Da	te Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling			1										
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process	_											,	
Supplier	_												
Training	_							}					
Transport								1					
Unapproved		<u> </u>				<u>L</u>							
						FAI	ULT CA	<b>TEGORY</b>					<del></del>
Landir F	g Gear				General		1		г				<b>-</b>
}	Bend	•		<u> </u>	Bend		1	Program	-		outside Dim	<u> </u>	Pressure/Forced
}	_	e Not Conce	ntric	$\vdash$	BOM/Route		Grain		-	_	ver/Under	<b>├</b>	Set-up
-	Crack		4	-	Broken/Damage/Defect	_	Hardwa		}	_	art Incorred	·	Temperature/Cure
-		/Kink/Rippl	e/Wave	$\vdash$	Burrs		1	ion Incomplete/U	. ·		art Lost/Mi	ssing	- Weld
}	Cuffs	ina		-	Counterpink	$\overline{}$	4	ions Incomplete/	<b> -</b>	_	art Moved	<u></u>	Wrong Stock Pulled
}	Crush	ıng Treat		<u> </u>	Countersink Cut Too Short	<u> </u>	1 7	gned/off center	}		ositioned W		Other
}		rreat ction Strip ir	Tubo		Drawing	<u> </u>	Mislabe Misrea		L	۳	ower Loss/S	ourge _	Totner
1	_	s/Chatter	riube	<u> </u>	Drill Holes	$\vdash$	Off-set			_			· <u></u>
}		ng Sequence	<b>.</b>	-	Finish	_	4	Calibration					<del></del>
	_	/Twist in Tu			Fit/Function	$\vdash$	ł	Sequence		_			
	1	,			1	ı	10000.						

DART AEROSPACE LTD	Work Order:	115704
Description: Rubber Cushion	Part Number:	D3595-063-530
Inspection Dwg: D3595 Rev: A		Page 1 of 1

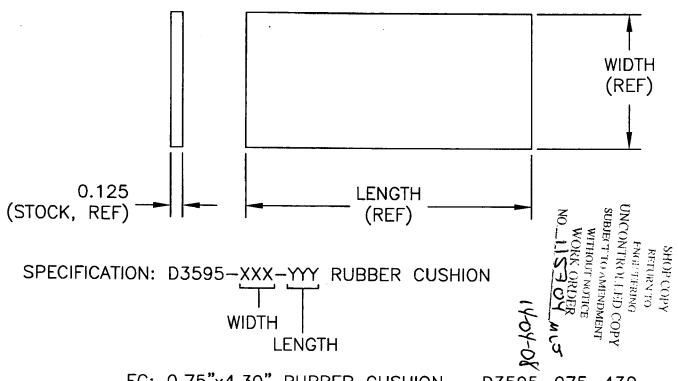
	X	First Artic	le 🗀	_ Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comi	ments
0.63	+/-0.030	0.63"	_		V	Jkmon	
5.30	+/-0.030	5,30"	_		V		
0.125	+/-0.010	0.63° 5.30° 0.125°	_		J		
						-	
	DAS		DA				
easured by:	23	Audited by:	1		Prototype	Approval:	N/A
Date: 16	<del>989</del> 4-09-9 .	Date:	14-	9-10		Date:	N/A



DESIG	PH	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA		
CHEC	KED ://	APPROVED //	DRAWING NO.		REV. A
	4	1	D3595	SHEET	1 OF 1
DATE		1	TITLE		SCALE
07.0	2.07		RUBBER CUSHION		NTS
Α		07.02.07	NEW ISSUE		



## SPECIFICATION CONTROL DRAWING



EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

## **NOTES**

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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